

Split  
Work Order ID 82288-2

March-28-12 12:54:42 PM

\*82288\*

Page 1

Item ID: D4436-045

Revision ID:

Item Name: Alt Inboard Bracket Assembly

Start Date: 28/03/2012 Start Qty: 600

Required Date: 11/04/2012 Req'd Qty: 6.00

Reference:

Accept

\*N900040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals: Process Plan: MLJ

QC:

Date: 12/03/28

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D4436

A

100

\*100\*

Waterjet

FLOW CNC Waterjet

Flowjet

FLOW WATER JET

0.00

Memo

0.00

1-Cut D4436-3 as per Dwg

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

110

\*110\*

QC

Quality Control

QC2- Inspect parts off machine FAD/ AHB

0.00

Memo

0.00

6

6

12-4-10

12-4-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 82288

March-28-12 12:54:42 PM

\*82288\*

Page 2

Item ID: D4436-045

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Alt Inboard Bracket Assembly

Start Date: 28/03/2012 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 11/04/2012 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals: Process Plan: Date: QC: Date:

Tooling: Date: SPC (Y/N): Date:

Run Start \*NR1\* Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

120

QC8- Inspect parts - second check

0.00

\*120\*

QC

Memo

0.00

Quality Control

130

Bend as per dwg

0.00

\*130\*

Brake NC

Memo

0.00

Brake NC

140

0.00

\*140\*

Small Fab

Memo

0.00

Small Fab

C"SINK AS PER DWG

8 r26/105

(H6)

8 r26/105

(6)

6x

8 r26/105  
12/16/05  
12/16/05



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 82288

March-28-12 12:54:42 PM

\*82288\*

Page 3

Item ID: D4436-045

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: All Inboard Bracket Assembly

Start Date: 28/03/2012 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 11/04/2012 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

\*150\*

QC

Memo

0.00

Quality Control

160

Chemical Conversion Coat per QS1005 4.1

0.00

\*160\*

Hand Finish

Memo

0.00

Hand Finishing

170

QC3- Inspect Part Finish

0.00

\*170\*

QC

Memo

0.00

Quality Control

Q

SB 126x/04



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 82288

March-28-12 12:54:42 PM

**\*82288\***

Page 4

Item ID: D4436-045

Revision ID:

Item Name: Alf Inboard Bracket Assembly

Start Date: 28/03/2012 Start Qty: 6.00

Required Date: 11/04/2012 Req'd Qty: 6.00

Reference:

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

180

**\*180\***

Small Fab

Small Fab

Memo

Assemble as per dwg. do not install grommets and rubber seal

0.00

185

**\*185\***

QC

Quality Control

QC 5- Inspect part completeness to step on W/C

Memo

0.00

0.00

190

**\*190\***

Powdercoat

Powder Coating

Black Sandtex(Ref 4.3.5.7) per QSI005.4.3

Memo

0.00

0.00

Start Time: 3:15

Temp: 72.00

Finish Time: 3:45

EXP

M/L  
12/06/12

W121274



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Work Order ID 82288

March-28-12 12:54:42 PM

\*82288\*

Page 5

Item ID: D4436-045

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Alt Inboard Bracket Assembly

Start Date: 28/03/2012 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 11/04/2012 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

200

QC3- Inspect Part Finish

0.00

\*200\*

QC

Memo

0.00

Quality Control

202

0.00

\*202\*

Small Fab

Memo

0.00

Small Fab

Install rubber seals and grommets, as per dwg

205

QC5- Inspect part completeness to step on W/O

0.00

\*205\*

QC

Memo

0.00

Quality Control

②

12/04/12

①

FF  
12-06-13

①

JP  
12/06/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 82288

March-28-12 12:54:42 PM

\*82288\*

Page 6

Item ID: D4436-045

Revision ID:

Item Name: All Inboard Bracket Assembly

Start Date: 28/03/2012 Start Qty: 6.00

Required Date: 11/04/2012 Req'd Qty: 6.00

Reference:

Accept

\*N9000040100\*

Setup Start \*NS1\*

Stop \*NS2\*

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

210

Identify as per dwg & Stock Location: GA

0.00

\*210\*

Packaging

Memo

0.00

Packaging

220

QC21- Final Inspection - Work Order Release

0.00

\*220\*

QC

Memo

0.00

Quality Control

12/6/14

ME 12-06-13



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

March-28-12 12:54:40 PM

Page 1

Work Order ID: 82288

Parent Item: D4436-045

Parent Item Name: All Inboard Bracket Assembly

\*82288\*

\*D4436-045\*

Start Date: 28/03/2012

Start Qty: 6.00

Required Date: 11/04/2012

Required Qty: 6.00

## Comments:

IPP revA 11.10.06 new issue EC verified by:DD  
11.12.22 per PA2 EC verified by:JLM  
PER DWG REV.A DD VERIFIED

IPP RevB  
IPP REV.C 12.01.24

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS35489-19 *MS35489-19* Grommet		Purchased	No			202	Each	103.0000	1	6			
**													

## Location

ST295

## Loc Qty

103

## Loc Code

100

sf

452.5000

0.689

4.351579

\*\*

## Location

MAT021

## Loc Qty

452.5

## Loc Code

121030

164.5

121099

288

202

f

182.6290

0.31

1.86

\*\*

## Location

prelim

## Loc Qty

6.739

## Loc Code

74760

6.739

ST413

175.89

79385

165.99

80763

9.9

cut qty 1 to 3.8"

①

FF 12-06-13

⑥

12-4-10

121030

.31

FF 12-06-13

# Picklist Print

March-28-12 12:54:46 PM

Page 2

Work Order ID: 82288

\*82288\*

Parent Item: D4436-045

\*D4436-045\*

Parent Item Name: Aft Inboard Bracket Assembly

Start Date: 28/03/2012

Required Date: 11/04/2012

Start Qty: 6.00

Required Qty: 6.00

D4441-1

Manufactured

No

T

182.6290

5.046

\*D4441-1\*

\*\*

Rubber Seal

FF 12-06-12

Location

Loc Qty

Loc Code

prelim

6.739

74760

6.739

ST413

175.89

79385

165.99

80763

9.9

cut qty 1 to 10.00"

MS20426AD3-2

2-3

Purchased

No

180

Each

18,319.00

4

24

\*MS20426AD3-2\*

\*\*

Rivet

FF 12-06-12

Location

Loc Qty

Loc Code

Mezz

18319

1173

8919

13276

9400

MS20470AD4-3

Purchased

No

180

Each

5,634.000

2

12

\*MS20470AD4-3\*

\*\*

Rivet - Universal Head

FF 12-06-02

Location

Loc Qty

Loc Code

Mezz

5634

1642

1000

2193

4634

March-28-12 12:54:46 PM

Shop Packet Print

Page 2



# Picklist Print

March-28-12 12:54:46 PM

Page 3

Work Order ID: 82288

\*82288\*

Parent Item: D4436-045

\*D4436-045\*

Parent Item Name: Aft Inboard Bracket Assembly

Start Date: 28/03/2012

Required Date: 11/04/2012

Start Qty: 6.00

Required Qty: 6.00

MS21075L08

Purchased

No

180

Each

249.0000

2

12

\*MS21075L 08\*

\*\*

ANCHOR NUT

Location

Loc Qty

Loc Code

ST303 121255

219

12

111578

2

120560

217

ST308

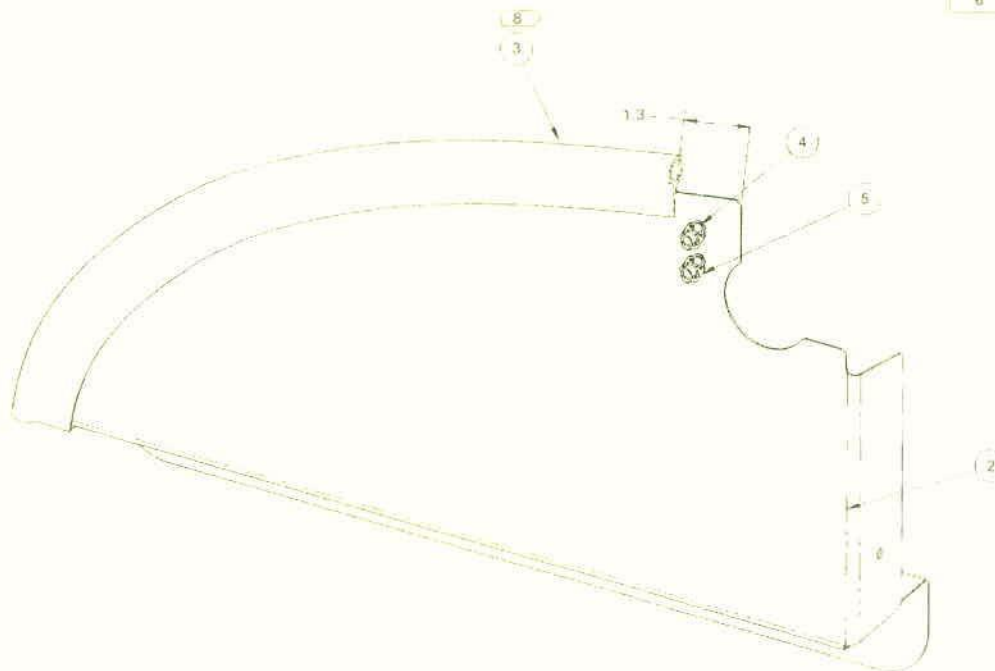
30

120930

30



ITEM	QTY	PART NUMBER	DESCRIPTION
	X	D4436-043	AFT OUTBOARD BRACKET ASSEMBLY
2	1	D4436-1	BRACKET
3	1	D4441-1-160	RUBBER SEAL
4	4	WS20426AD3	RIVET
5	2	WS21075L08	NUT PLATE
6	A/R	3M 1300/1300L	ADHESIVE



**D4436-043 AFT OUTBOARD BRACKET ASSEMBLY**

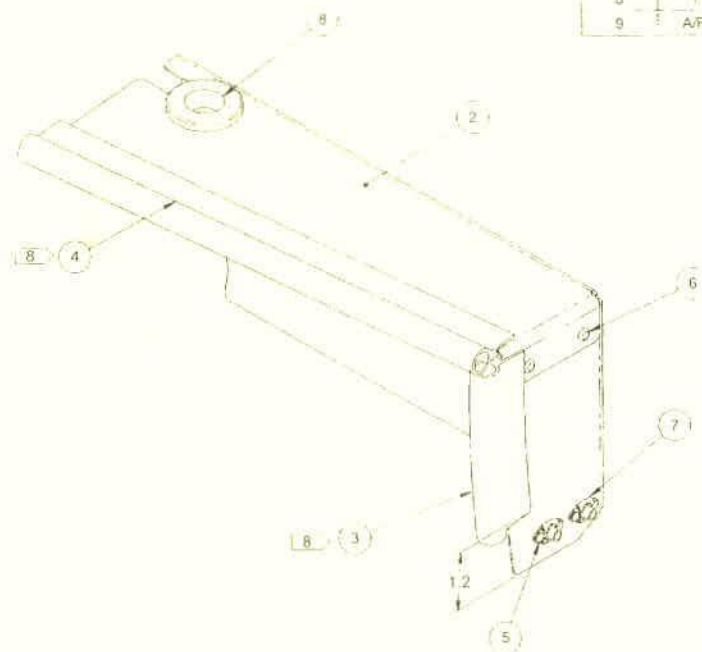
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANTEX" (4.3.5.7) PER DART QSI 005 4.3  
MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE  
ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL  
IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO <b>D4436</b>	REV. A
MFG APPR.	RF		SHEET 2 OF 7
APPROVED	RF	TITLE <b>COVER ASSEMBLY</b>	SCALE NTS
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ITEM	QTY -045	PART NUMBER	DESCRIPTION
1	X	D4436-045	AFT INBOARD BRACKET ASSEMBLY
2	1	D4436-3	BRACKET
3	1	D4441-1-034	RUBBER SEAL
4	1	D4441-1-104	RUBBER SEAL
5	1	MS20426AD3-1	RIVET
6	2	MS20470AD4-3	RIVET
7	2	MS21075L08	NUT PLATE
8	1	MS35489-19	GROMMET
9	A/R	3M 1300/1300L	ADHESIVE

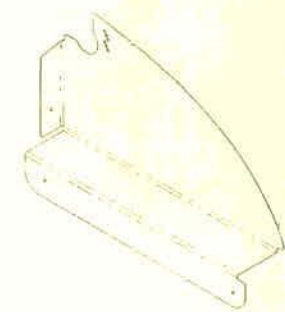
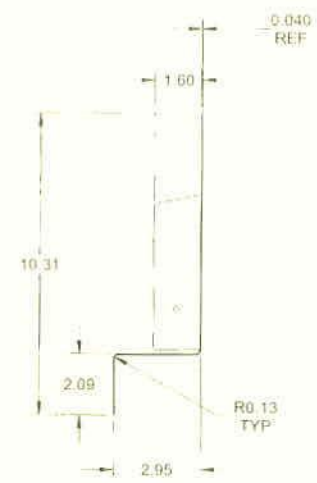
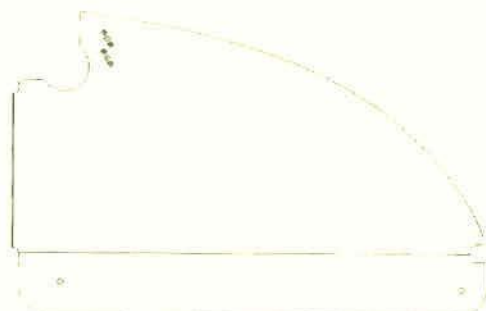


**D4436-045 AFT INBOARD BRACKET ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANTEX" (4.3.5.7) PER DART QSI 005 4.3 MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.42 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE. ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL. IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO. <b>D4436</b>	REV. A
MFG. APPR.	RF	TITLE <b>COVER ASSEMBLY</b>	SHEET 3 OF 7
APPROVED	RF	SCALE	NTS
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82288

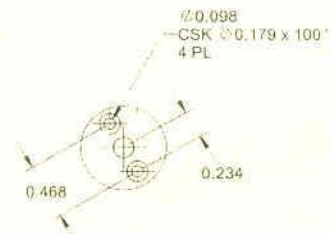
# D4436-1 BRACKET

RELEASED  
12-01-23  
MD

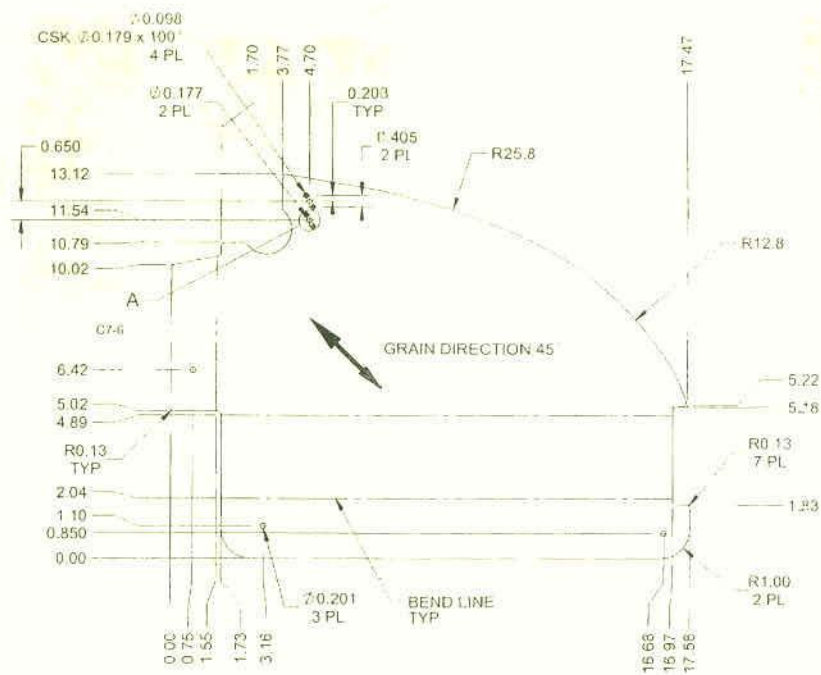
## NOTES:

- 1) MATERIAL: MAKE FROM D4436-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.69 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4436	SHEET 4 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR	<i>[Signature]</i>	COVER ASSEMBLY	NTS
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DETAIL A C6-6  
SCALE 4X, TYP



D4436-1F FLAT PATTERN

NOTES:

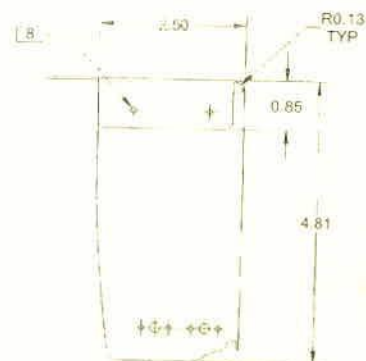
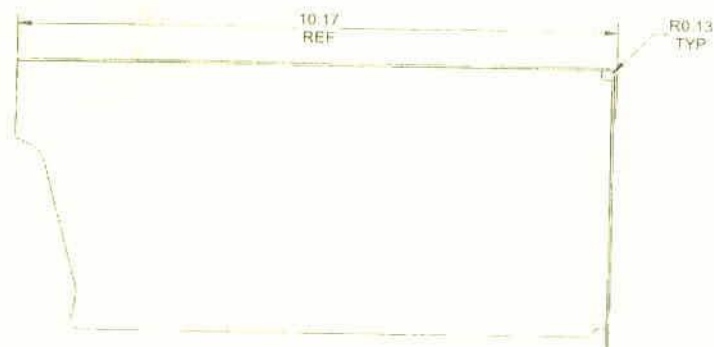
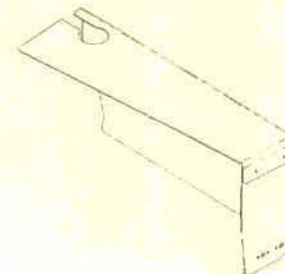
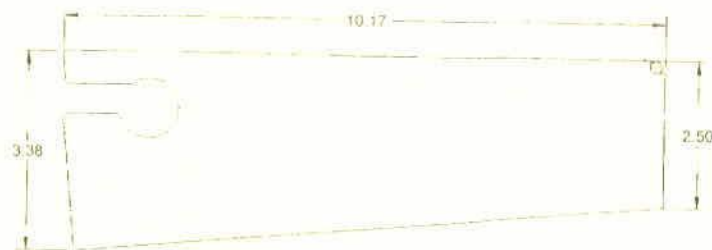
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.69 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D4436	REV. A
MFG. APPR.	RF	TITLE COVER ASSEMBLY	SHEET 5 OF 7
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DATE	12.01.17		

022288

RELEASED  
2012-07-23





82288

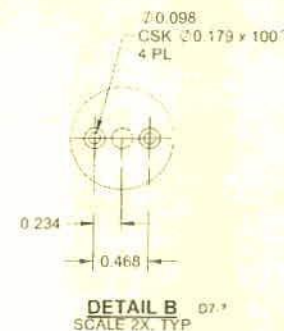
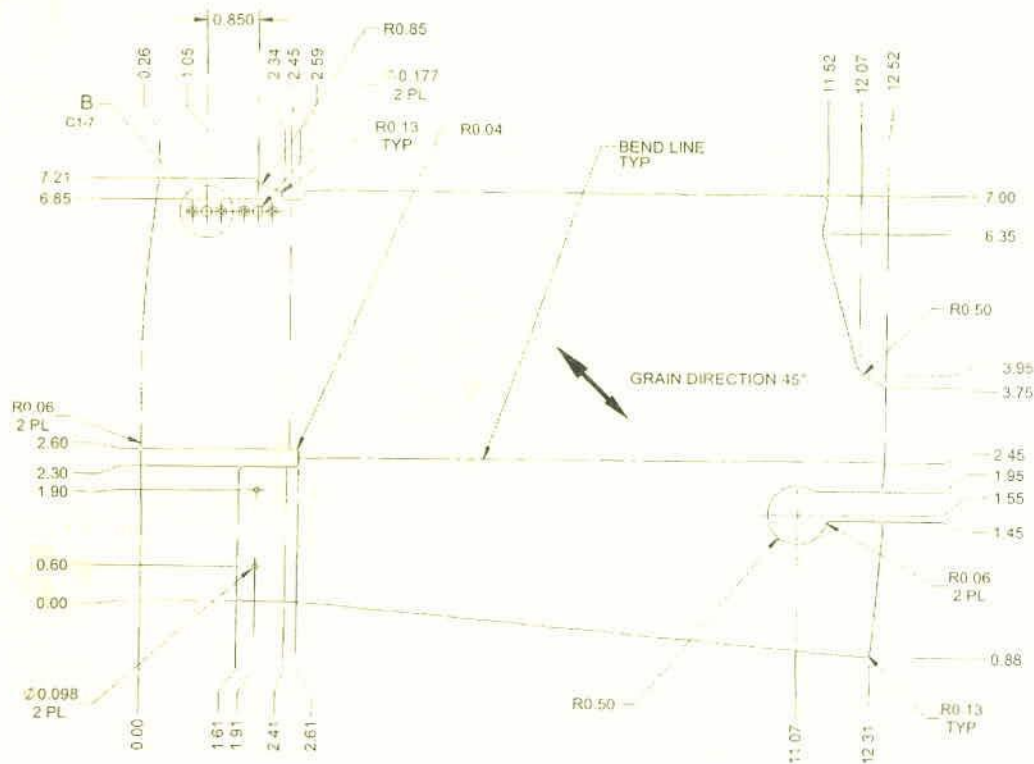
# D4436-3 BRACKET

FILED IN  
12-21-23

## NOTES:

- 1) MATERIAL: MAKE FROM D4436-3F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs
- 8) TRANSFER Ø0.129 HOLES THRU 2 PLACES

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D4436	REV. A
MFG. APPR.	RF		SHEET 6 OF 7
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	COVER ASSEMBLY	NTS
DATE	12.21.17	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS NOT TO BE DISCLOSED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	



# **D4436-3F FLAT PATTERN**

## **NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.33 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	<b>D4436</b>	SHEET 7 OF 7
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	<b>COVER ASSEMBLY</b>	NTS
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